

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013226**Date Inspected:** 17-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou ChengZhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Segment 9DE**

During random visual inspection of segment 9DE this QA inspector found following issue.

Root opening more than 5 mm observed on weld#SSD17-PP81-46, 47. According to approved drawing this weld is fillet weld joining DP699 stiffener (grade 485) to FL3-FB24A. ZPMC personal performed carbon arc gouging on these fillet weld to make it Complete joint penetration (CJP). ZPMC personal submitted a request to the engineer for change this joint fillet to CJP and get approval.

For further information, please see the attached pictures below.

**Bay#19**

During random in process inspection of Bike Path, BK4A-004, this QA inspector observed that ZPMC performed base metal repair on BKPL1A and BKPL2A. After removing the outer cover plate by carbon arc gouging, ZPMC MT technician performed Magnetic particle testing and found indications. This base metal repair performed with SMAW welding process.

**Segment 12BW**

This QA inspector performed MT of carbon arc back gouging. The member is identified as OBG Components.

The weld designations reviewed are as follows:

-(Seg3005D-016)

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## WELDING INSPECTION REPORT

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Bay#14

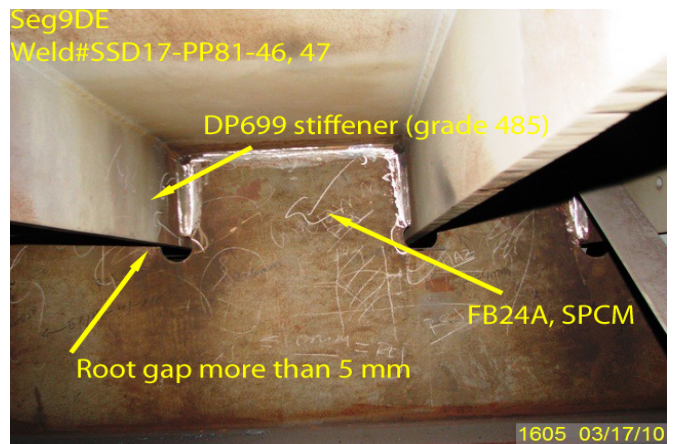
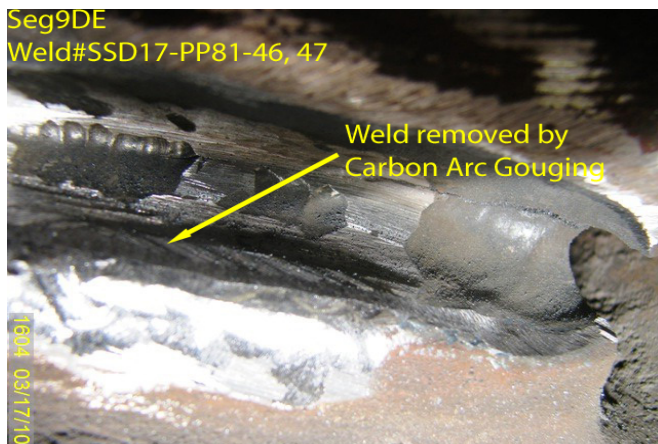
FCAW welding of weld joint CA3008D-037/038 located on CA3008D, Lift 12CW. Welder is identified as 045175 (2F). ZPMC QC is identified as Li Hua Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint CA3010D-237/238 located on CA3010D, Lift 12CW. Welder is identified as 045175 (2F). ZPMC QC is identified as Li Hua Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint CA3010E-265/266 located on CA3010E, Lift 12CW. Welder is identified as 045175 (2F). ZPMC QC is identified as Li Hua Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint CA3010E-271/272 located on SegmentCA3010E, Lift 12CW. Welder is identified as 045175 (2F). ZPMC QC is identified as Li Hua Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Patel,Hiranch

Quality Assurance Inspector

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**Reviewed By:** McClendon,Timothy

QA Reviewer